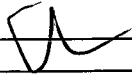



Date: Thursday, 12/20/2007 3:21:49 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 36489	
Estimate Number : 12959	
P.O. Number : <b>N/A</b>	Part Number : D36421
This Issue : 12/20/2007 S.O. No. : <b>N/A</b>	Drawing Number : D3642 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : <b>N/A</b> Type : SMALL /MED FAB	Drawing Revision : <b>U/R</b> <b>B</b> <b>12/21/21</b>
Previous Run : 34545	Material : <b>N/A</b>
Written By : 	Due Date : 1/10/2008 Qty: 10 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S050	2024-T3 .050 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1747 sf(s)/Unit Total : 1.7472 sf(s)

2024-T3 .050 sheet

Batch: **105646** **UB 8-1-7**

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3642

Dwg Rev: **B** **UB 8-1-7**

Prog Rev: **B**

2-Deburr if necessary **UB 8-1-7**



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

**UB 8-1-7**

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

**08/01/07** **(12)**

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

**BL** **08-21-12**



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:21:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36489

Part Number: D36421

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



12X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

08/01/12

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: 178

8/1/14 SD

12X

8.0

QC21

FINAL INSPECTION/W/O RELEASE



12

Comment: FINAL INSPECTION/W/O RELEASE

08/01/15

Job Completion



a 08.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	36489
Description: Doubler		Part Number:	D3642-1
Inspection Dwg: D3642	Rev: <u>A/B</u>	Page 1 of 1	

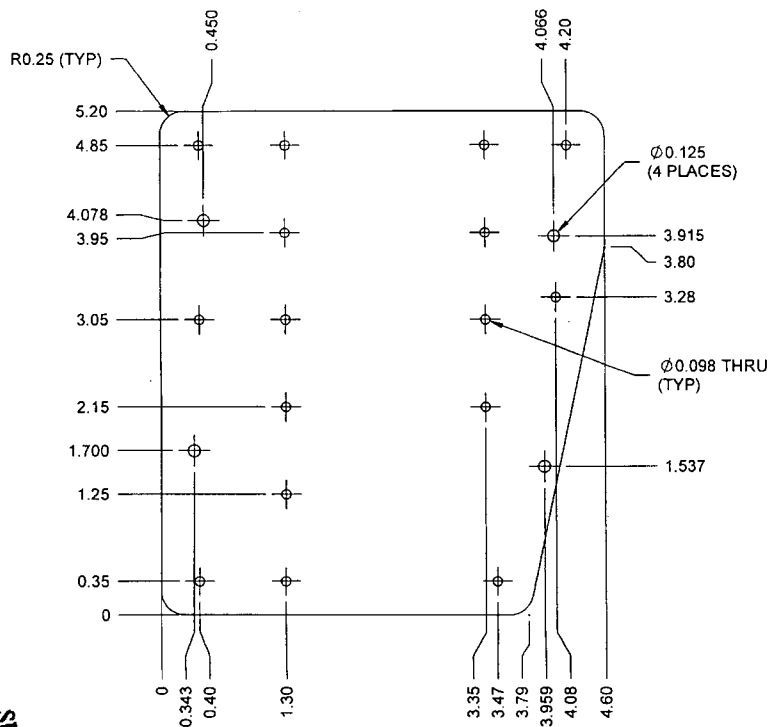
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

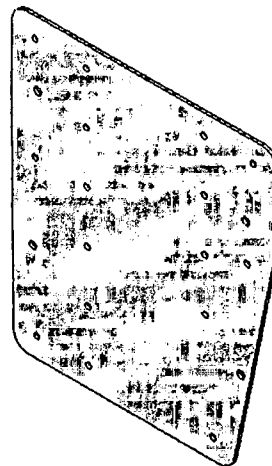
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.125	+0.004/-0.001	.126	X			
Ø0.098	+0.004/-0.001	.099	X			
0.35	+/-0.030	.35	X			
1.25	+/-0.030	1.25	X			
1.700	+/-0.010	1.703	X			
2.15	+/-0.030	2.15	X			
3.05	+/-0.030	3.05	X			
3.95	+/-0.030	3.95	X			
4.078	+/-0.010	4.078	X			
4.85	+/-0.030	4.853	X			
5.20	+/-0.030	5.209	X			
0.343	+/-0.010	.343	X			
0.40	+/-0.030	.403	X			
1.30	+/-0.030	1.35	X			
3.35	+/-0.030	3.35	X			
3.47	+/-0.030	3.472	X			
3.79	+/-0.030	3.79	X			
3.959	+/-0.010	3.959	X			
4.08	+/-0.030	4.08	X			
4.20	+/-0.030	4.20	X			
4.60	+/-0.030	4.60	X			
1.537	+/-0.010	1.539	X			
3.28	+/-0.030	3.28	X			
3.80	+/-0.030	3.80	X			
3.915	+/-0.010	3.918	X			

Measured by: <u>JB</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	N/A
Date: <u>8-1-7</u>	Date: <u>28/01/02</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD <u>[Signature]</u>	<u>[Signature]</u>



D3642-1 DOUBLER (WAS GENEVA P/N G10607-1/-2)



RELEASED  
07.10.16

SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36489

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S 050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3642-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

B	REMOVE -2; UPDATE -1 TO INCLUDE G10607-2	LE	07.10.16
A	NEW ISSUE; REPLACES G10607	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	US		
CHECKED	AL		
MFG. APPR.	EG		
APPROVED	TH		
DE APPR.	TH	DRAWING NO. <b>D3642</b> TITLE <b>DOUBLER</b>	
DATE	07.10.16	REV. B SHEET 1 OF 1 SCALE 4:5 <small>COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	